

Work Order ID 79621

79621

Page 1

January-30-12 2:41:07 PM

Item ID: D3805-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plate
 Start Date: 30/01/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 13/02/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: M.L.S Date: 12/01/30 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3805 | B |

100 0.00

100 0.00 12 02 08 (22)

Waterjet Memo
 FLOW CNC Waterjet 1-Cut as per Dwg D3805
 301 .056 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110 0.00 12 02 08 (22)

QC Memo
 Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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 Start Date: 30/01/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 13/02/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|---------|-------------|--------------|----------------|---------------|------------------|----------------|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | 8/2/02/09 | | count (722) | | | |
| 130 *130* Brake NC Brake NC | Memo Form as per Dwg D3805 using Jigs DT8261 and DT8326 | 0.00 0.00 | | SB 12/03/01 | | (22) | | | |
| 140 *140* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | 8/2/03/01 | | count (722) | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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 Start Date: 30/01/2012 Start Qty: 20.00 ***20*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | Identify as per dwg & Stock Location: <u>W/A</u> | 0.00 | | | | | | | |
| *150* | | | | | | (22) | MAL | 12/03/01 | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/3/2 *[Signature]*
 MF
 12-03-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

January-30-12 2:41:11 PM

Page 1

Work Order ID: 79621

79621

Parent Item: D3805-1

D3805-1

Parent Item Name: Plate

Start Date: 30/01/2012

Required Date: 13/02/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-07-15 new issue DD verified by:EC
IPP Rev:B 08-07-30 redesign flat pattern DD verified by:EC
IPP Rev:C 08-09-23 redesign flat pattern DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S18GA

Purchased

No

100

sf

468.0050

3.8542

81.14105

M304S18GA

**

12.02.08

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

468.005

119032

49.3

119383

96

119766

66.705

120243

256

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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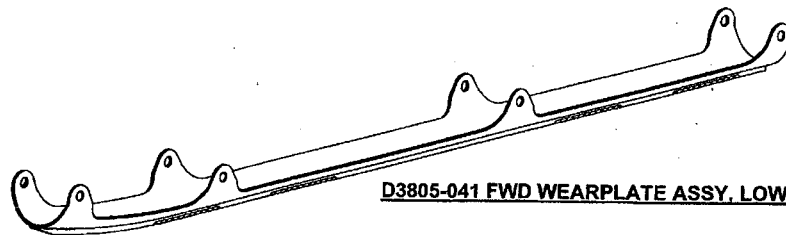
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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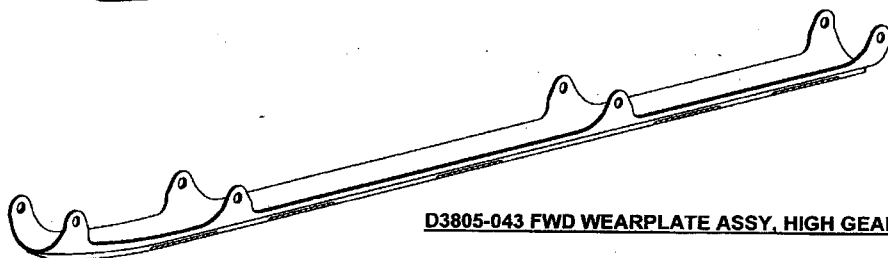
NOTE: Date & initial all entries

8 7 6 5 4

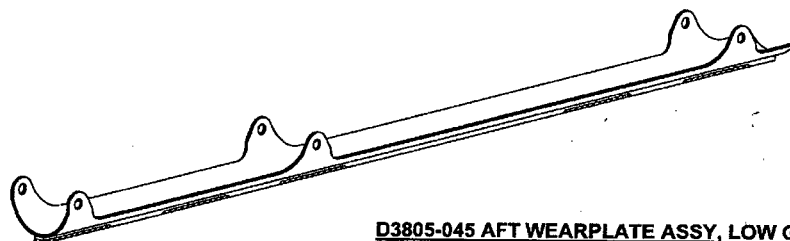
3 2 1



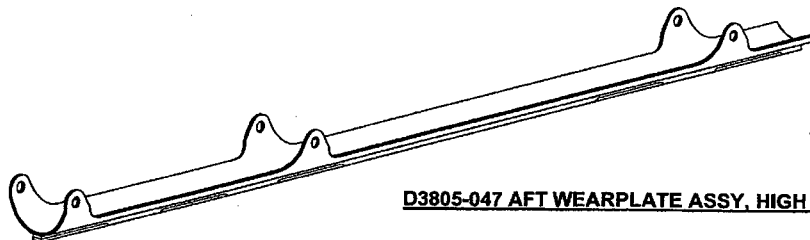
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4

| ITEM | QTY -041 | QTY -043 | QTY -045 | QTY -047 | P/N | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|--------------------|-------------------------------|
| 1 | X | | | | D3805-041 | FWD WEARPLATE ASSY, LOW GEAR |
| 2 | | X | | | D3805-043 | FWD WEARPLATE ASSY, HIGH GEAR |
| 3 | | | X | | D3805-045 | AFT WEARPLATE ASSY, LOW GEAR |
| 4 | | | | X | D3805-047 | AFT WEARPLATE ASSY, HIGH GEAR |
| 11 | 1 | | | | D3805-1 | PLATE |
| 12 | | 1 | | | D3805-3 | PLATE |
| 13 | | | 1 | | D3805-5 | PLATE |
| 14 | | | | 1 | D3805-7 | PLATE |
| 15 | 1 | | | | D3806-1 | BAR |
| 16 | | 1 | | | D3806-3 | BAR |
| 17 | | | 1 | | D3806-5 | BAR |
| 18 | | | | 1 | D3806-7 | BAR |
| 19 | 1 | | | | D3807-1 | GASKET |
| 20 | | 1 | | | D3807-3 | GASKET |
| 21 | | | 1 | | D3807-5 | GASKET |
| 22 | | | | 1 | D3807-7 | GASKET |
| 31 | A/R | A/R | A/R | A/R | 2059B | HARDCOAT |
| 32 | A/R | A/R | A/R | A/R | 1300 (OR 1300L) | 3M SCOTCH-GRIP ADHESIVE |

SHOWN BY
REVISION
ENCLOSURE
UNCONTROLLED COPY
SUBJECT TO
WITHDRAWAL
WORK CENTER
NO. 37621 M.C.

12/01/30

RELEASED
2011-10-03

| | | | |
|------------|---|----|----------|
| B | REVISED D3805-1F7-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3 | MB | 11.09.16 |
| A | NEW ISSUE | MB | 08.11.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 4 | | |
| DRAWN | 4 | | |
| CHECKED | 4 | | |
| MFG. APPR. | 4 | | |
| APPROVED | 4 | | |
| DE APPR. | 4 | | |
| DATE | 11.09.16 | | |

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. D3805
REV. B
SHEET 1 OF 8

TITLE WEARPLATE ASSY
SCALE NTS

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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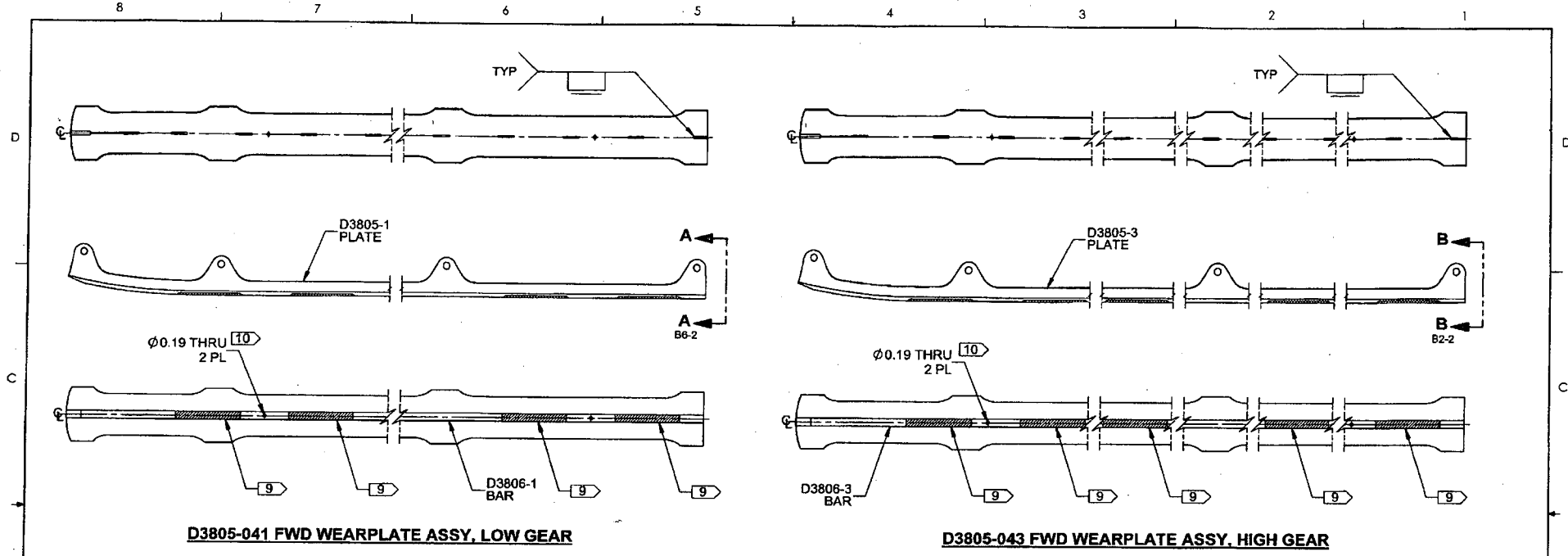
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

79621



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | | | |
| CHECKED | | DRAWING NO. D3805 | REV. B |
| MFG. APPR. | | | SHEET 2 OF 8 |
| APPROVED | | TITLE WEARPLATE ASSY | SCALE NTS |
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| DATE | 11.09.16 | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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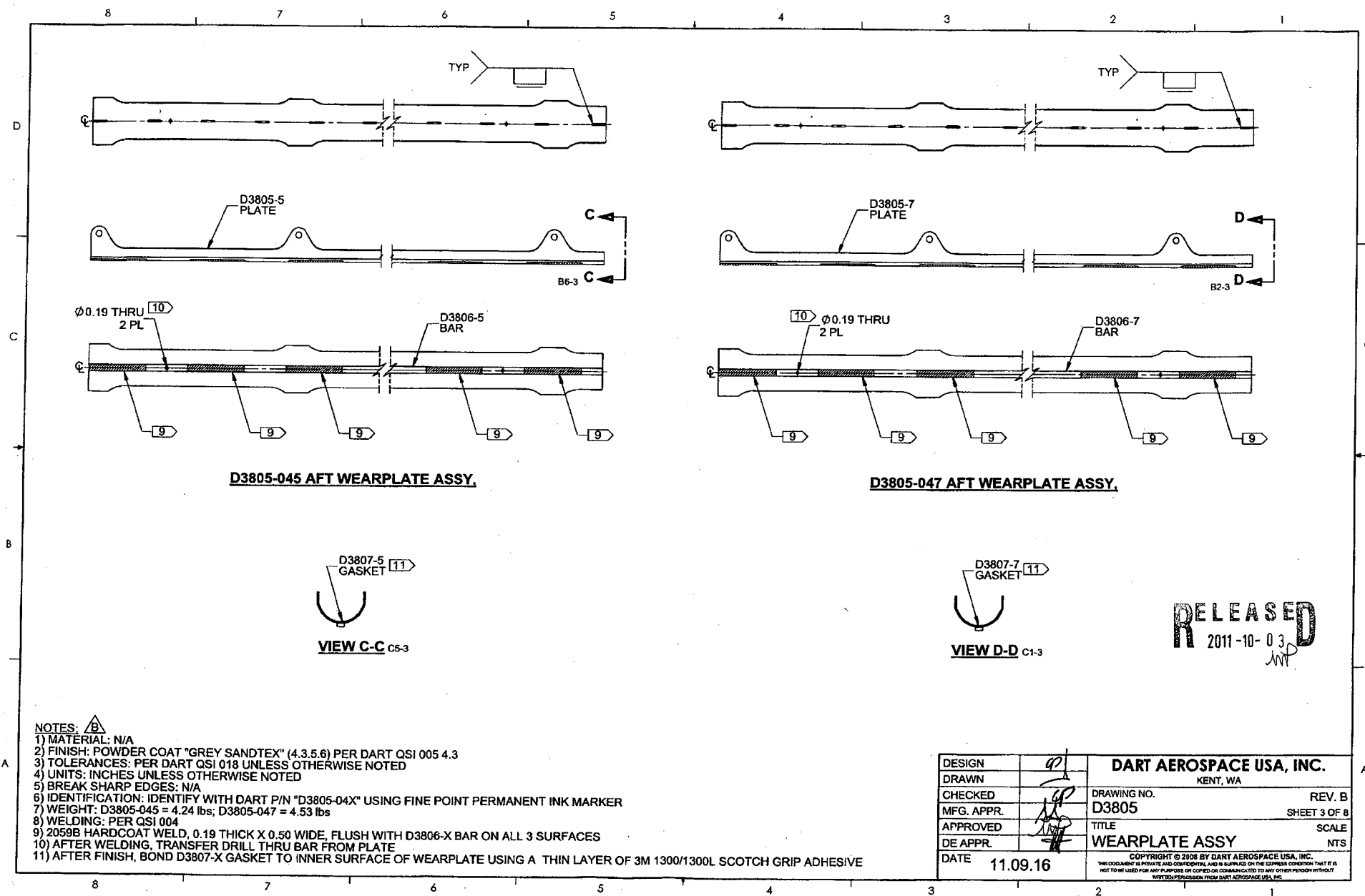
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NOTE: Date & initial all entries

79621



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|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3805 | SHEET 3 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARPLATE ASSY | NTS |
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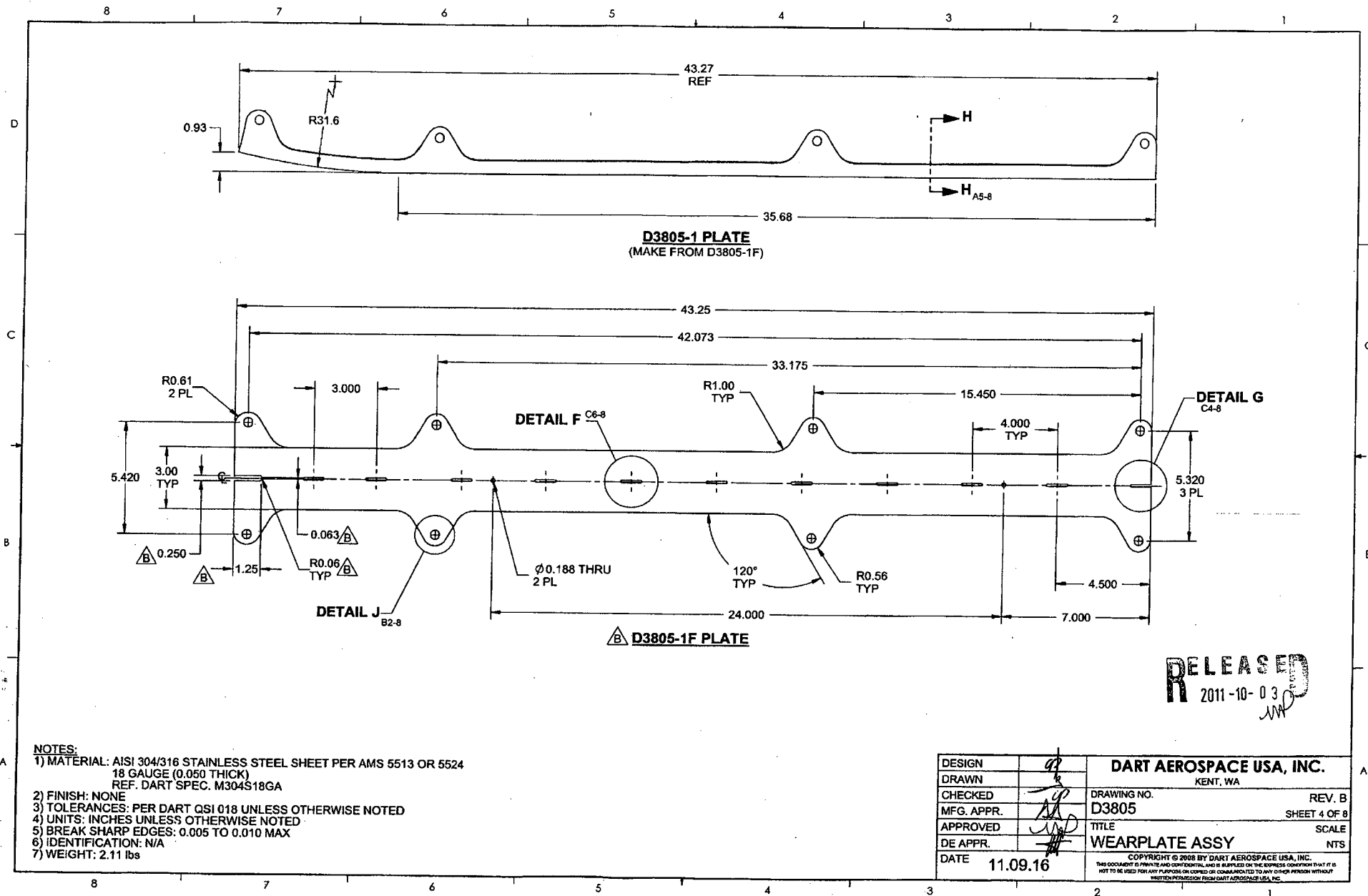
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NOTE: Date & initial all entries

79621



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.11 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3805 | SHEET 4 OF 8 |
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RELEASED
2011-10-03
JW

| W/O: | | WORK ORDER CHANGES | | | | | |
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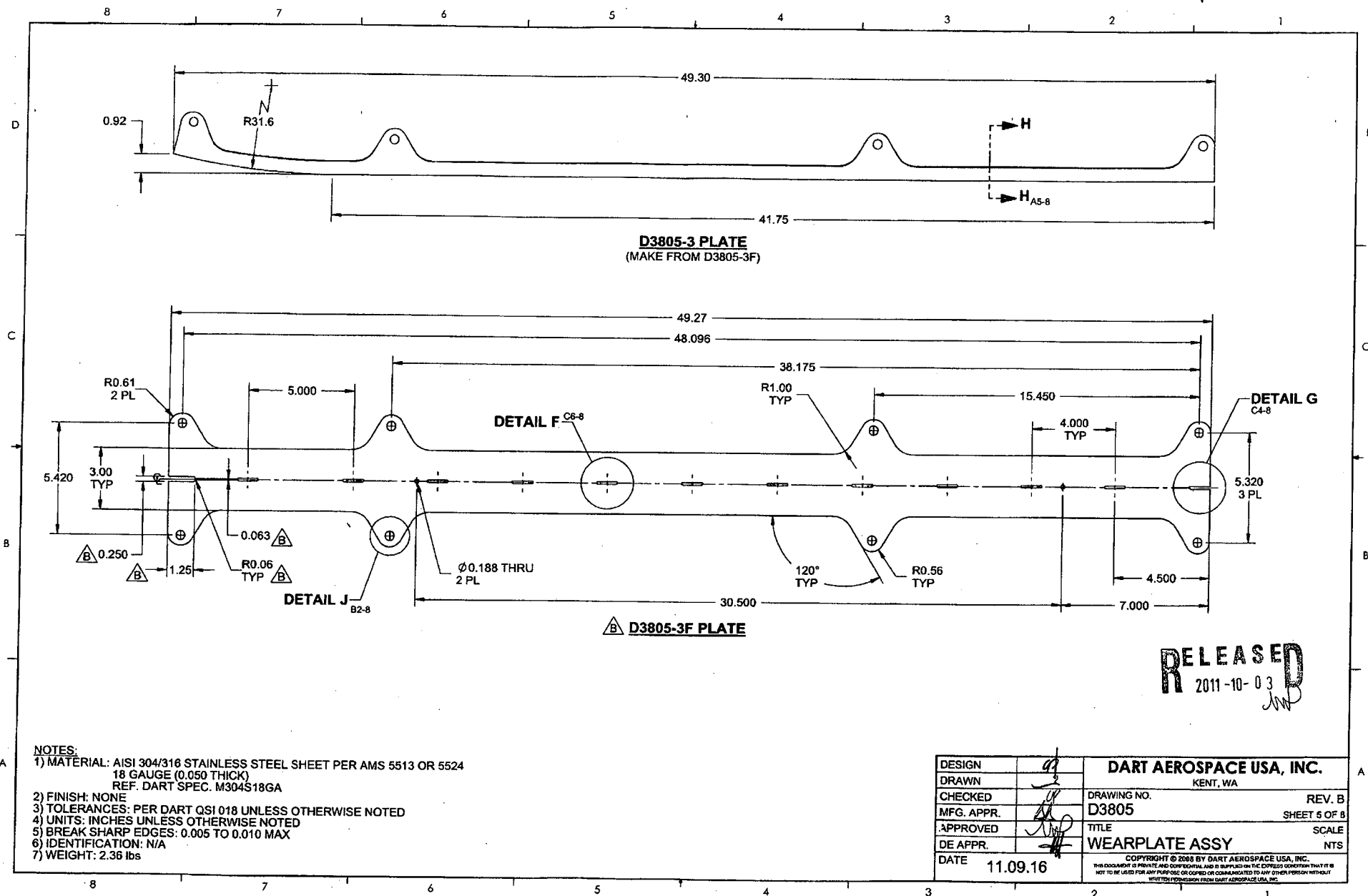
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.36 lbs

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|------------|----------|---|--------------|
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| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. B |
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Dart Aerospace Ltd

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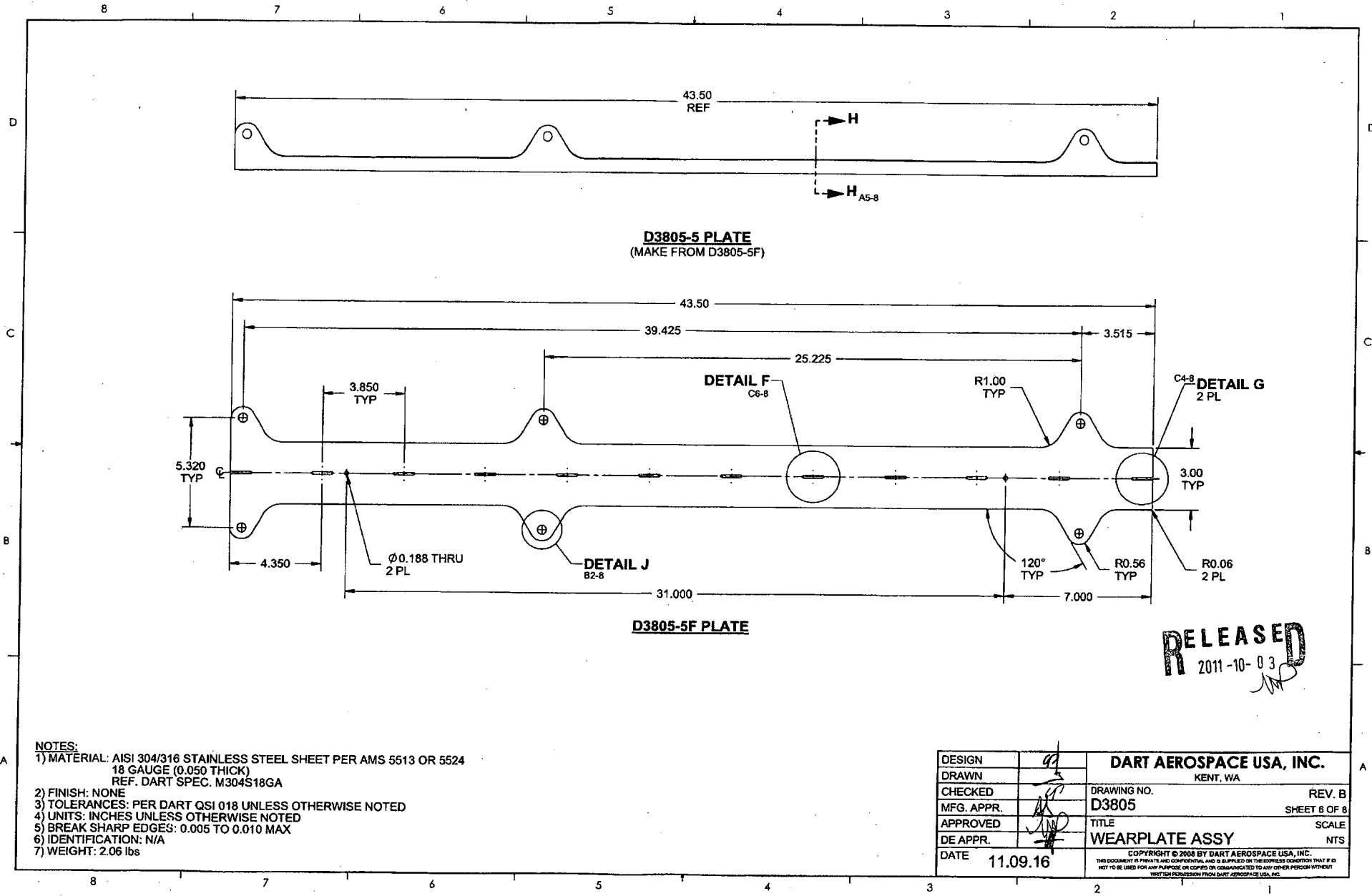
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NOTE: Date & initial all entries

29621



D3805-5 PLATE
(MAKE FROM D3805-5F)

D3805-5F PLATE

RELEASED
2011-10-03

NOTES:

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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

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| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3805 | SHEET 6 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARPLATE ASSY | NTS |
| DATE | 11.09.16 | <small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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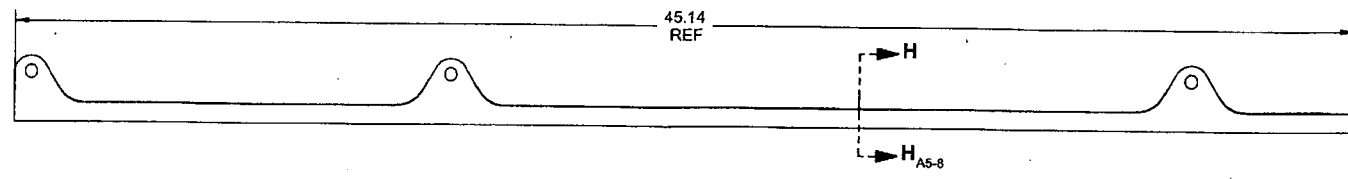
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

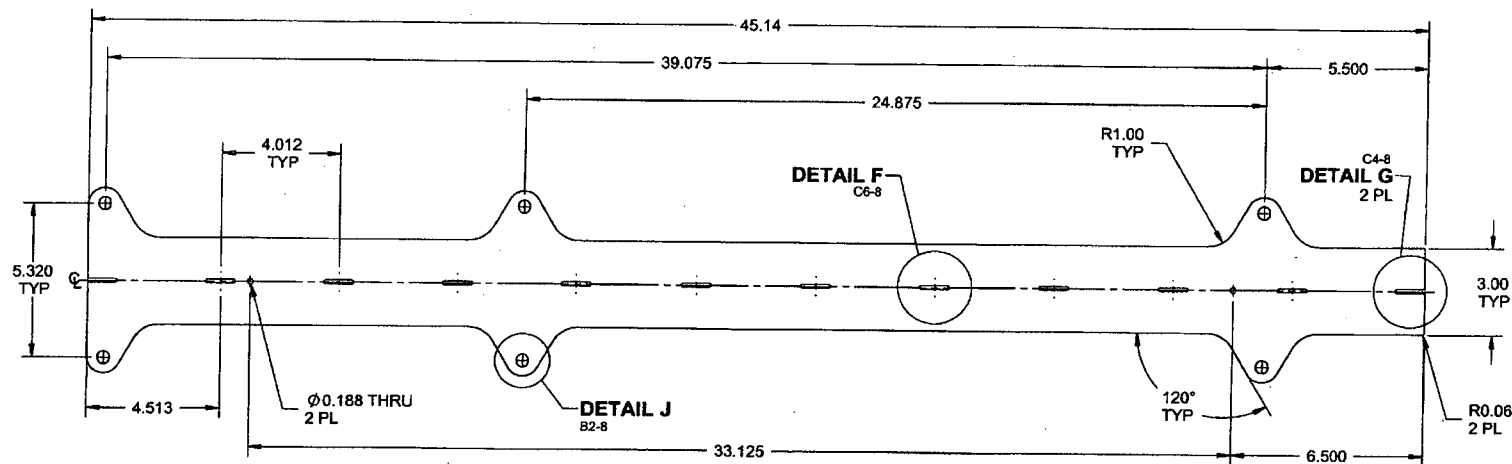
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

79621



D3805-7 PLATE
(MAKE FROM D3805-7F)



D3805-7F PLATE

RELEASED
2011-10-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

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|------------|----------|---|--------------|
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| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3805 | SHEET 7 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARPLATE ASSY | NTS |
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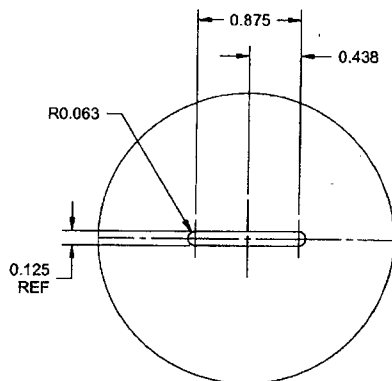
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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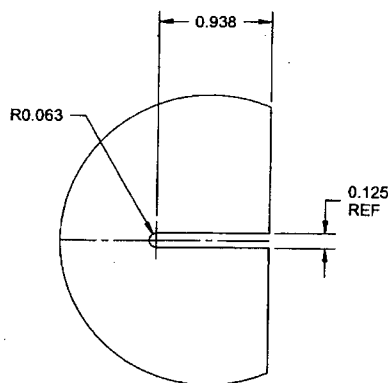
NOTE: Date & initial all entries

79621



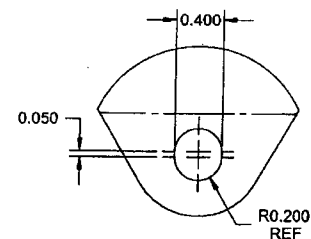
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



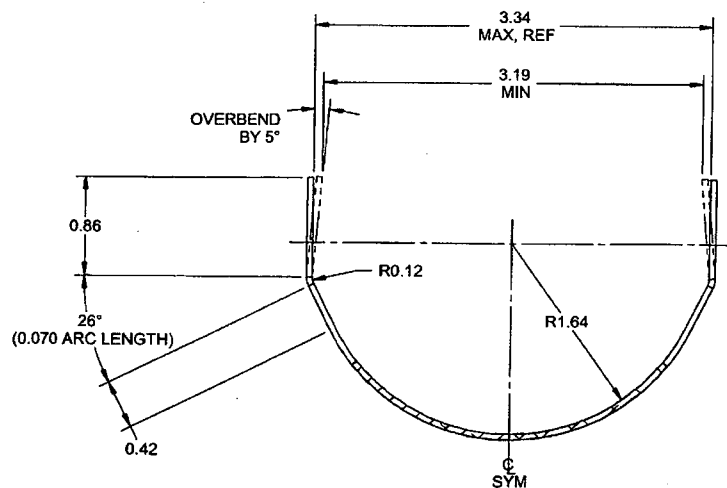
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

RELEASED
2011-10-03

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| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. D3805 | REV. B |
| MFG. APPR. | | SHEET 8 OF 8 | |
| APPROVED | | TITLE WEARPLATE ASSY | SCALE NTS |
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NOTE: Date & initial all entries